



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D119-796-251
Job Sheet 176936



Part No: D119-796-251

Job Qty: 1 ea

Part Name: Aft Crosstube Installation With Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D119-796-251 REV E, IIN-D119-796 REV F IPP REV:A 14.09.09 NEW ISSUE DD VERF:JLM IPP
REV:B 14.10.15 AS PER REV.A DD VERF:JLM IPP REV:C 14.11.19 AS PER REV.C DD VERF:JLM IPP
REV:D 14.12.09 AS PER REV.PC6 DD VERF:JLM IPP REV:E 15.02.11 AS PER REV D JLM VERF:DD IPP
REV:F 17.12.11 REMOVE PACK KIT DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/31/18	5/31/18	0.00	0.00	Start Up Crosstubes-1		AS JUN 27 2018
130	Crosstubes	1 pcs	5/31/18	5/31/18	0.00	0.51	Crosstubes-1		AS JUN 27 2018
140	QC	1 pcs	5/31/18	5/31/18	0.00	0.00	QC5		15-06-27
145	DC	1 pcs	5/31/18	5/31/18	0.00	0.00	DC		NR
150	Packaging	1 pcs	5/31/18	5/31/18	0.00	0.00	Packaging3-1	LGOSO	AS JUN 27 2018
160	QC21-FG	1 Ea	5/31/18	5/31/18	0.00	0.00	QC21		21 JUN 27 2018

Part Op 130 - 1- Install step and clamp with the proper position per dwg D119-796-251 ***Torque all clamps to 50-100 lbs max.
Descriptions: 140 - ***RE-CHECK TORCQUE ON CLAMP AS PER DWG.***

145 - Photocopy bluefile and create labels as per PPP D119-796-251 chg 004

150 - Identify and pack for shipping as per PPP D119-796-251

JUN 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D119-796-241	Aft Crosstube Installation Without Step (No Hardware)	1 Ea (1 ea)	90-Start up Operation	
D5123-3	Clamp Cushion	4 Ea (4 ea)	90-Start up Operation	
D5149-043	Aft Step Base Assembly	2 Ea (2 ea)	90-Start up Operation	
MS21920-25	Clamp	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation (170327)	D119-796-241 5048509	①	7	0
	D5123-3 5063952	④	294	0
	D5149-043 5039113	②	5	0
	MS21920-25 5068660	④	97	0



Container No: S085027



Part: D119-796-251

Job No: 176936

Serial No/Batch: S085027

Revision: E/F

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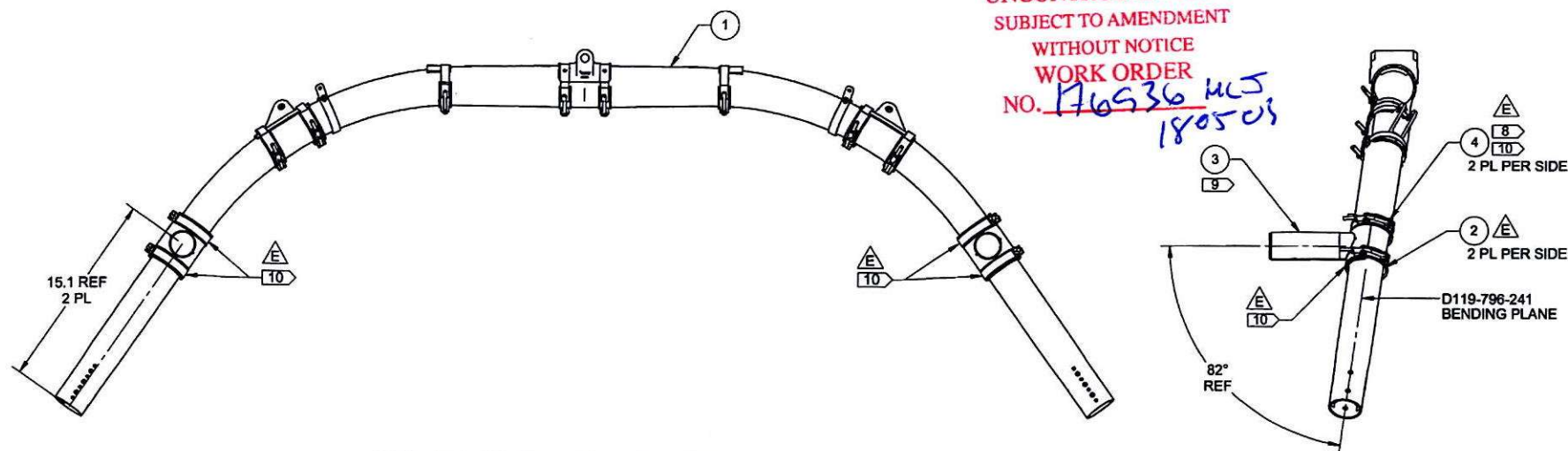
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be found.

Plex 5/3/18 10:10 AM Dart.lajeunesse.marie

ITEM	QTY -251	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 176536 MLJ
180501



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
 - 7) WEIGHT: 29.9 lbs
 - 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
 - 9) LOCATE STEP USING POST FITTING ON CROSSTUBE
 - 10) POSITION MS21920 CLAMPS SECURING THE STEPS AS SHOWN.
- THE THREADED PORTION OF THE CLAMP MUST FACE THE SAME DIRECTION AS THE STEP

E	MODIFY CLAMP ORIENTATION, ADD NOTE 10, REMOVED SECTION A-A (PAR16-527)	ML	17.02.10
D	D5123-3 WAS D5123-9, MS21920-25 WAS -28, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D119-796-251 REV. E SHEET 1 OF 1 TITLE XTUBE ASSY (AW119 MKII AFT) SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	ML		
CHECKED	NO		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS-#	DATE 17.02.10	

RELEASED
2017-05-04
ECN17-538

APPROVED